

Date: Monday, 11/21/2005 1:17:56 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	: 24856			Part Number	: D29332	
Estimate Number	: 10834			Drawing Number	: D2933 REV B	
P.O. Number	: N/A			Project Number	: N/A	
This Issue	: 11/21/2005 S.O. No. : N/A			Drawing Revision	: B	
Prsht Rev.	: NC			Material	: N/A	
First Issue	: N/A			Due Date	: 12/21/2005	
Previous Run	: N/A			Qty:	4 Um: Each	
Written By	: SEE COMMENT Below					
Checked & Approved By	: SEE APPROVED USER & DATE					
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: 24890
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ML 06/04/21 4

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SD 06:04:22 (4)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/25 (4)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10/6/21 (4)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST475

Al 06/04/27 (4)

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/04/28 (4)

Job Completion



(L06/04/28)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.123	.121	.122		
B	0.100	0.140		.123	.123	.123	.123		
C	0.100	0.140		.120	.119	.120	.118		
D	0.210	0.230		.221	.221	.220	.222		
E	1.245	1.255		1.250	1.249	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.576	1.576	1.577	1.577		
J	2.495	2.505		2.499	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.239	.240	.240	.239		
N	0.100	0.140		.120	.120	.119	.119		
O	0.540	0.560		.550	.549	.550	.550		
P	0.490	0.510		.500	.499	.498	.499		
Q	3.715	3.725		3.720	3.719	3.719	3.720		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.247	.251	.250	.251		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.135	1.136	1.135	1.136		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L	Audited by:	DMZ
Date:	06-04-21	Date:	06/04/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024856
Project Name : D2933-2
Project For : WK551
Work Order Type : Main
Main WO Number :
House Part Number : D2933-2
Description : 206 Saddle Right
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 11-17-05
Est Finish Date : 12-21-05
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd :
Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Date: Friday, 4/28/2006 7:16:59 AM

User: Chantal Lavoie

**INVENTORY ITEMS PICKED
FOR SLIP NUMBER 2130**

Project No. : Drawing Number : D2933 REV B
Customer : Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Part Number : D29332 Due Date : / /
Job Number : 24856 Qty : 4
Slip # : 2130

	Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0 D6101001 7075-T7351 2X6X6.25 Available 245.00		MAIN		24890	4.00	4.0000 Each	